

Work Order ID 81050

81050

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Item ID: D206-559-013

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw

Start Date: 07/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/07 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D206-559	rev L								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D206-559-013	CHG006							
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC4- 100% Inspect kits for completeness	0.00							
170									
QC	Memo	0.00							
Quality Control									

5/26/3/14

MLJ 12-3-14
(6)

6x SP 12-03-14

5/26/3/14

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop ***NS2***

Item Name: Bearpaw

Start Date: 07/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 21/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Packaging	0.00							
180									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD206-559-013 Location: <u>12</u> <u>RCW3</u>								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

12/3/14

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 81050

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Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:J04.02.17Blank size changedKJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-17A		Purchased	No			160	Each	470.0000	12	120 72			
AN4-17A									**				
Bolt													

Location	Loc Qty	Loc Code
ST358	24	
112314	8	
116419	16	
116704	0	
ST359	446	
118983	300	
120187	146	

AN4-20A

AN4-20A

Bolt

Purchased No

160 Each 446.0000 12

Location	Loc Qty	Loc Code
GA	50	
116419	50	
ST359	396	
117514	96	
118983	100	
119127	200	

72 72

SP

72 45X

272

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 81050

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Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN960JD416 NAS1149D0463J Purchased No

160 Each 20.0000 24

AN960JD416

Washer

**

240 144.

m/20644 SP.

Location

Loc Qty

Loc Code

ST351

20

116289

20

D2182B Manufactured No

160 f 403.3942 2.5

D2182B

Rubber Cushion

**

25 15

Location

Loc Qty

Loc Code

ST410

403.39417

63413

1.6

66063

41.61817

73932

360.176

(D2182B050) cut qty (6) at 5.00" as per dwg ***per kit***

D2274 Manufactured No

160 Each 147.0000 12

D2274

Radius Block

**

120 72

SP.

Location

Loc Qty

Loc Code

ST007

147

72121

32

78589

115

D2432 Manufactured No

160 Each 0.0000 2

D2432

206 (24") Bearpaw

**

20 12

B80733

SP 12-03-14.

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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D206-559-013

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2438

Manufactured No

160 Each

86.0000 6

**

D2438

Clamp

Location

Loc Qty

Loc Code

ST456

86

77038

8

78594

78

Manufactured No

160 Each

417.0000 12

**

D2529

D2529

Washer

Location

Loc Qty

Loc Code

ST010

417

66953

2

79221

275

79485

140

Manufactured No

160 f

197.3353 2.5

**

D2732

D2732

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

197.335299

70987

197.335299

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D206-559-013

D206-559-013

Parent Item Name: Bearpaw

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 10.00

Required Qty: 10.00

MS21042L4

Purchased

No

160

Each

4,298.000

12

120

MS21042I 4

Nut

**

Sp 12-03-14

Location

Loc Qty

Loc Code

ST300

4298

117441

51

117601

157

118451

133

119017

200

119075

3757

~~60~~ 72

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X	-						D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP